

Date: Monday, 07/04/2008 11:47:14 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 38430		
Estimate Number	: 13093		
P.O. Number	:	Part Number	: D3492053
This Issue	: 07/04/2008 S.O. No. :	Drawing Number	: D3492 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 37474	Material	:
	Type : MACHINED PARTS	Due Date	: 11/04/2008
Written By	:	Qty:	20 Um: Each
Checked & Approved By	: <u>JD 08.4.06</u>		
Comment	: Est Rev:A New Issue 06-06-20 JLM		
	Est Rev:B as per Rev C 07-12-06 DD		

## Additional Product

Job Number: ~~38430~~

Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.0481 f(s)/Unit Total: 0.9618 f(s)  
 6061-T6 Round Bar .750"  
 (M6061T6R0750)  
 Batch: M103857

mmf / ml 08/04/08

(20)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA715 & Dwg D3492  
 Dwg Rev: C  
 Folio Rev: AA

mmf / ml 08/04/08

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf / ml 08/04/08

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

36 08.04.08

20

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

CB 08/04/08 (20)

Date: Monday, 07/04/2008 11:47:14 AM  
User: Julie Lecocq

# Process Sheet

30 min

17/04/2008

S.046 13.59

#1 330.7 F  
#2 38430 F  
#3 03492053 F  
#4 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38430

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-04-17

7.0

POWDER COATING

POWDER COATING



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

BL 08-04-17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/17

9.0

NAS1611012

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-012 O-RING

m/07137

FL

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: m/01223

FL 08/04/17

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/17 (20)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP-1

FL

08/04/17 (20)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/21

Job Completion

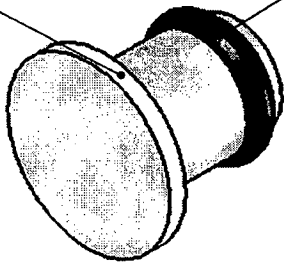


MF 08-04-18



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



**D3492-XXX PLUG PARTS LIST**

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



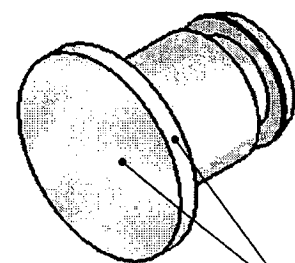
NOTES:  
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

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WITHOUT NOTICE  
WORK ORDER  
NO. 38430

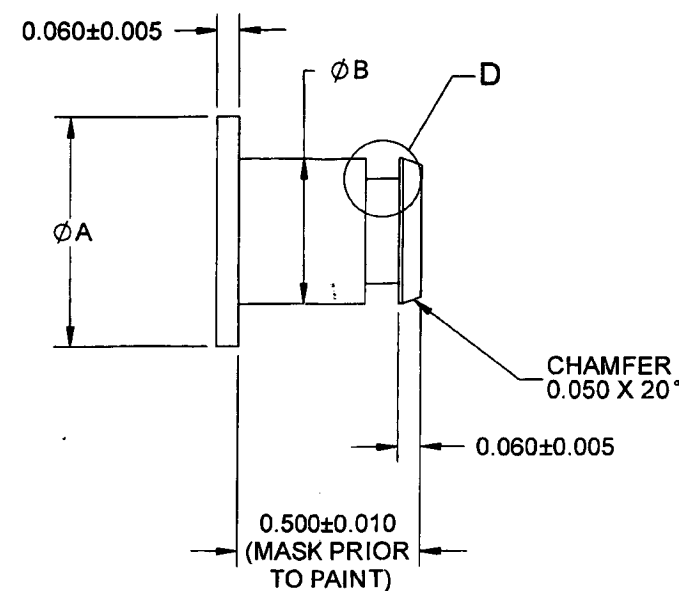
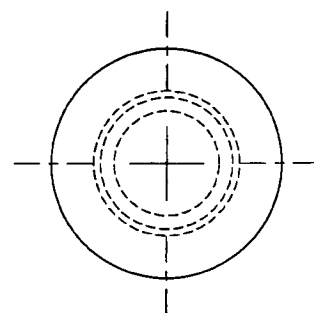
RELEASED  
07.10.05

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PL</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PL</i>		
CHECKED	<i>PL</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PL</i>	D3492	SHEET 1 OF 2
APPROVED	<i>PL</i>	TITLE	SCALE
DE APPR.	<i>PL</i>	PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

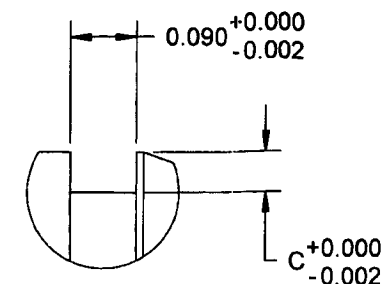




POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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NO. 38430

**RELEASED**  
07.11.16

DESIGN	<i>RA</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RA</i>		
CHECKED	<i>RA</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RA</i>	<b>D3492</b>	SHEET 2 OF 2
APPROVED	<i>RA</i>	TITLE	SCALE
DE APPR.	<i>RA</i>	<b>PLUG</b>	4:1
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